

Work Order ID 158577

Monday, March 27, 2017 10:56:58 AM

158577

Page 1

Item ID: D2121 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Clamp Assembly
Start Date: 3/27/2017 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 4/7/2017 Req'd Qty: 6.00 ***6*** Customer:
Reference: SCHEDULED/C

Approvals: Process Plan: MF Date: 17-3-27 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2121	Rev D

100 0.00

100

Large Fab

Large Fab

Memo

1.14

Large Fab

Weld washer & wing nut as per Dwg D2121 & QSI 004
Identify as Wing Nut assembly

6DYC17/03/28

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Memo

0.00

Quality Control

617-03-29DAS99-89

120

0.00

120

Small Fab

Small Fab

Memo

1.42

Small Fab

Assemble parts from steps 5-14 and Wing Nut Assembly as per Dwg D2121.
Drill and deburr hole in coupling nut as per Dwg D2121.
(Note: Install MS21042L4 Nut loosely)
Cut D2771-BCFC-025-150 at 1.500"

617-3-230DAS199-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.12				<u>6</u>			DAS 38 9-89 MAR 30 2017
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: ST000 M222 Memo	0.00 0.06				<u>6</u>			DAS 6 9-89 MAR 30 2017
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.60							17/4/3 DAS 21 9-89 MAR 31 2017

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

Picklist Print

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Page 1

Work Order ID: 158577

158577

Parent Item: D2121

D2121

Parent Item Name: Clamp Assembly

Start Date: 3/27/2017

Required Date: 4/7/2017

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: D04.05.27Added Step 2-3; changed Step 4 KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

5/16-18 SS JAM NUT
5/16-18 SS JAM NUT
 Jam Nut

Location	Loc Qty	Loc Code
GA	49	
110084	49	
Mezz	45	
16016	45	

**

17-3-30

DAS
19
9-89

5/16-18 SS
 THREADED
5/16-18 SS THREADED
 Threaded Rod 6.5" long

Location	Loc Qty	Loc Code
GA	23	
121239	15	
121486	8	

**

17-3-30

DAS
19
9-89

5/16-18 SS WING NUT
5/16-18 SS WING NUT
 Wing Nut

Location	Loc Qty	Loc Code
WA001	92	
110084	92	

**

DYC 17/03/28

6

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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OTHER : _____					

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Work Order ID: 158577

158577

Parent Item: D2121

D2121

Parent Item Name: Clamp Assembly

Start Date: 3/27/2017

Required Date: 4/7/2017

Start Qty: 6.00

Required Qty: 6.00

5/16-18SS1COUPLING

Purchased

No

120

Each

25.0000

1

6

5/16-18SS1COUPLING

**

17-3-30

DAS
19
9-89

Coupling Nut mcmaster p/n: 90268A030

Location

Loc Qty

Loc Code

GA

23

M130477

23

Mezz

2

16016

2

5/16WC

Purchased

No

100

Each

783.0000

1

6

5/16WC

**

DYC 17/03/28

DAS
19
9-89

Washer

Location

Loc Qty

Loc Code

ST583

783

WASHER m136525

183

m137100

600

AN4-4A

Purchased

No

120

Each

42.0000

1

6

AN4-4A

**

17-3-30

DAS
19
9-89

BOLT

Location

Loc Qty

Loc Code

over003

20

m137061

20

ST346

22

m129390

22

D2012-107

Manufactured

No

120

Each

19.0000

1

6

D2012-107

**

17-3-30

DAS
19
9-89

Clevis

Location

Loc Qty

Loc Code

ST001

9

157180

9

WA004

10

156167

10

Monday, March 27, 2017 10:56:58 AM

Shop Packet Print

Page 2

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Work Order ID: 158577

Parent Item: D2121

Parent Item Name: Clamp Assembly

158577
D2121

Start Date: 3/27/2017
Required Qty: 6.00
Required Date: 4/7/2017

DAS 19 8-89
17-3-30

D2529 *D2529* No Manufactured

Washer

Location

ST008

155073

157443

Loc Qty

120

Each

520.0000

**

30

Loc Code

6

1

**

696.0000

120

Each

D2771-BCFC-025-150

D2771-BCFC-025-150

Bolt

Location

GA

8754

Mezz

8754

Loc Qty

25

25

671

671

Loc Code

6

1

**

681.0000

120

Each

D2771-CC-025

D2771-CC-025

Lock Nut

Location

GA

8493

Mezz

4554

8493

Loc Qty

93

93

588

6

582

Loc Code

6

DAS 19 8-89

17-3-30

DAS 19 8-89

17-3-30

DAS 19 8-89

17-3-30

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

Picklist Print

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Work Order ID: 158577

158577

Parent Item: D2121

D2121

Parent Item Name: Clamp Assembly

Start Date: 3/27/2017

Required Date: 4/7/2017

Start Qty: 6.00

Required Qty: 6.00

MS21042L4

Purchased

No

120

Each

1,297.000

1

6

MS21042I 4

**

17-3-30

DAS
19
9-89

Nut

Location

Loc Qty

Loc Code

FP001

10

m133363

10

GA

172

m135058

172

OVER007

500

m136986

500

ST303

615

m136450

500

m136838

115

6

NAS1149D0463J

Purchased

No

120

Each

1,959.000

1

6

NAS1149D0463.I

**

17-3-30

DAS
19
9-89

Washer

Location

Loc Qty

Loc Code

GA

67

M134508

13

M135056

54

ST263

1892

M136838

892

M136983

1000

6

DQA: _____ Date: _____

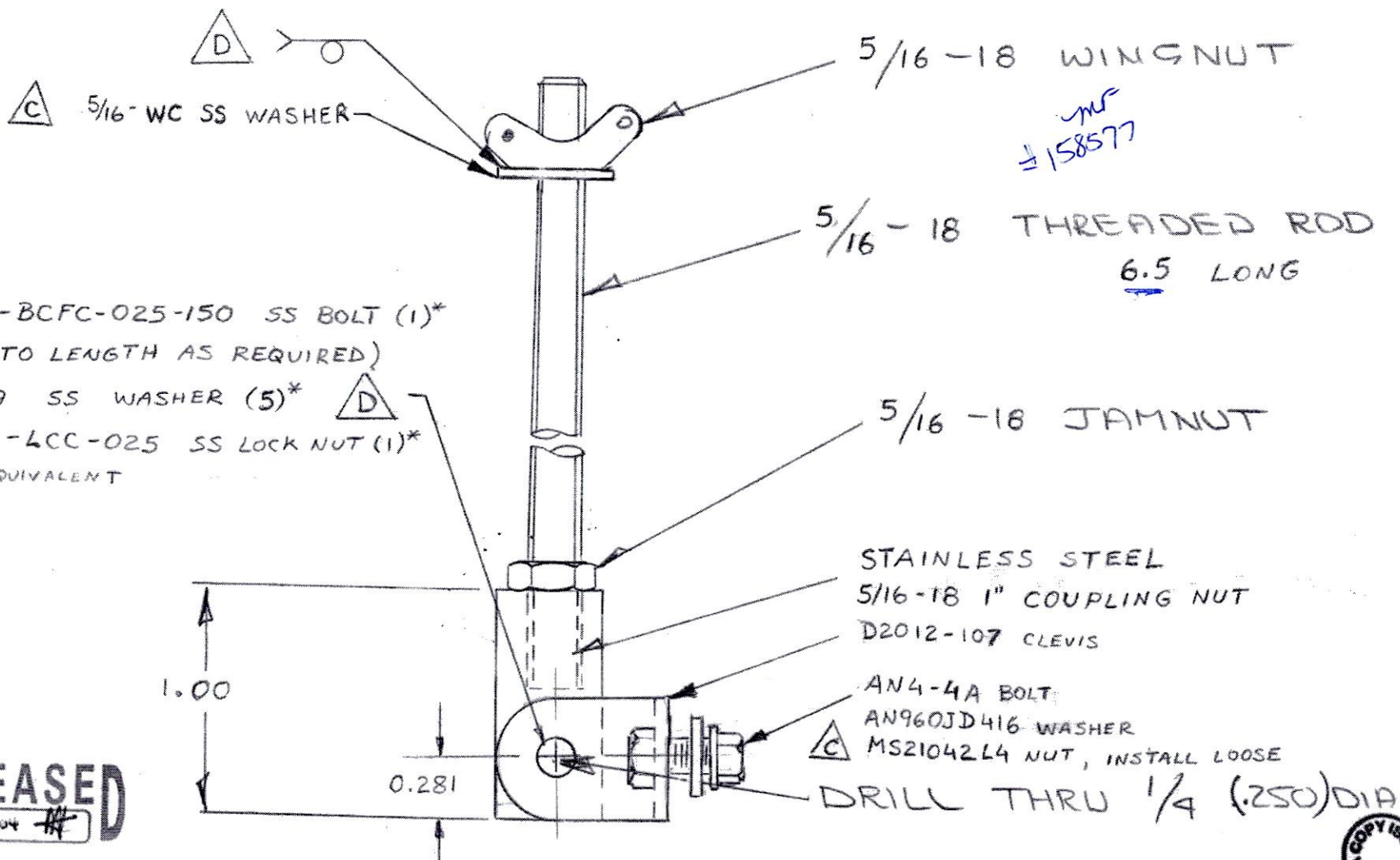


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OTHER :					



RELEASED
04.05.04



D	C	B	-	REVISION	RIVET CODE SHALL BE PER NAS 523		PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC./VENDOR
1	2	3	4	DRAWN	BASIC CODE		CONTRACT NO.			DART	DART AERO ACCESSORIES INC. VANCOUVER CANADA
5	6	7	8	APPROVED	DIA DASH NO. W-HEAD WEAR SIDE P-HEAD FAR SIDE		DESIGN	DATE			
REQUIREMENTS — UNLESS OTHERWISE SPECIFIED GENERAL 1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS 125-1 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER MIL - 8 - 7742 5. HOLES PER AND 10387 LIMITS 1. TOLERANCES — JOK & .030 2. ANGLES XXX & .010 3. PARALLELISM & .0075 4. ECCENTRICITY .005 MAX 5. SYMMETRY ABOUT ALL M/C CENTRE LINES .005					D-DIMPLE DASH-NO OF SHEETS C-COUNTERSINK		LENGTH DASH NO. W-SPOTWELD		TITLE CLAMP, BATTERY		
					BASIC CODES		CODE				
					BLM-MS2043040 BB-MS2043640		DWG NO D2121				
					REPORT ALL DISCREPANCIES — DO NOT SCALE		SCALE NTS				
04.04.15 ADDED NOTES 03.01.17 ADDED FASTENERS REV. DIM 99.08.18 NEW ISSUE 92.03.17					SHIT 1 OF 1						

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OTHER : _____					